

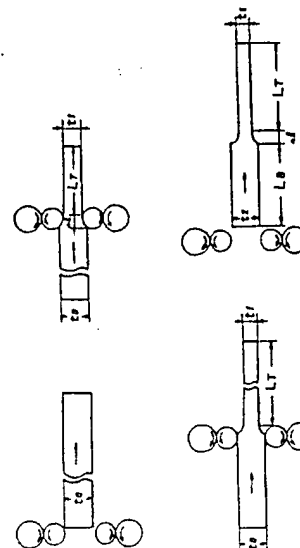
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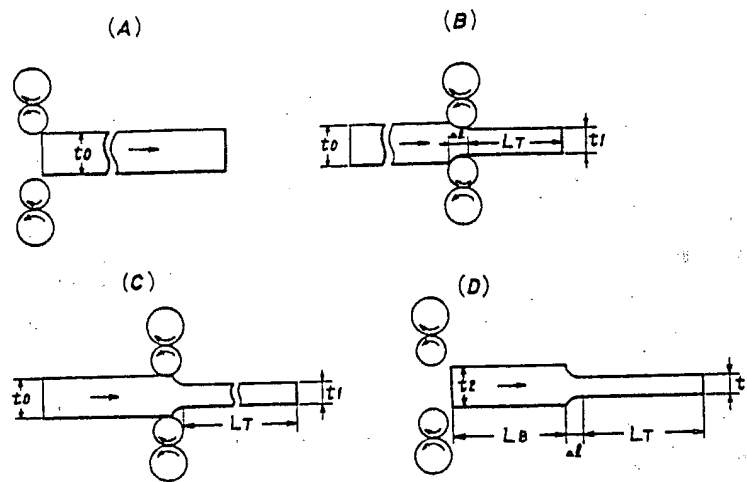
**(54) ROLLING OF STEEL THICK PLATE****(11) 61-172603 (A)** (43) 4.8.1986 (19) JP**(21) Appl. No. 60-14917** (22) 29.1.1985**(71) SUMITOMO METAL IND LTD** (72) YASUHIRO YAMAMOTO**(51) Int. Cl. B21B1/38**

**PURPOSE:** To obtain a different-thickness rolling stock excellent in flatness and yield, by lowering the number of revolutions of rolls and controlling roll crowns in accordance with a load variation, at the time of changing a roll gap.

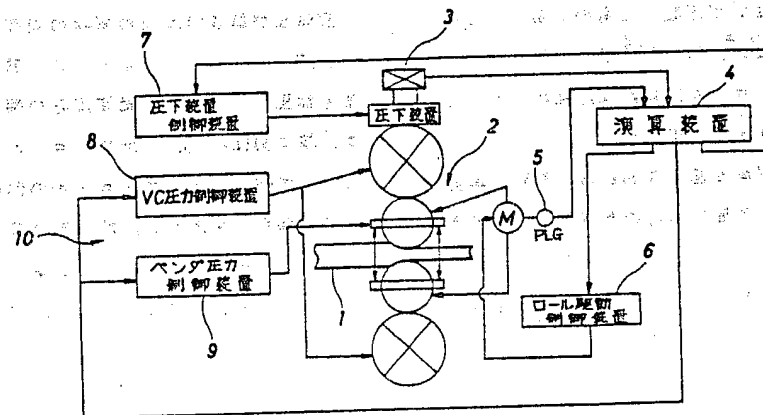
**CONSTITUTION:** A heated slab is rolled by a conventional method into a rolling stock 1 of plate thickness  $t_0$ . Next, a roll opening is set so as to obtain a plate thickness  $t_1$ , and the number of revolutions of roll is set to ordinary about 50~80rpm to roll the stock 1 from its front end into the length of LT. At that time, the number of revolutions of roll is lowered to  $\leq 20$ rpm to perform low-speed rolling as well as the roll opening is enlarged so as to obtain the plate thickness of  $t_0$  or  $t_2$ . That is, at the time of changing a roll opening, the number of revolutions of roll is lowered, and the roll crown is controlled in accordance with a load variation so that a thickness variation in the plate width direction is not produced, till the prescribed roll opening is obtained. After the prescribed roll opening is obtained, the number of revolutions of roll is returned to the ordinary ones to roll the stock as far as its rear end. In this way, a different-thickness rolling stock having a different-thickness part short in length, can be formed.



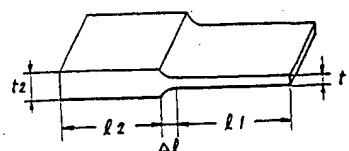
第 1 図



第 2 図



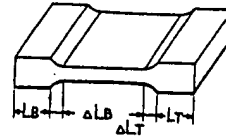
第 3 図



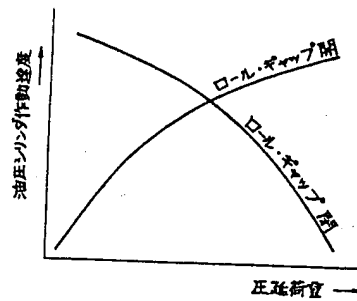
第 4 図



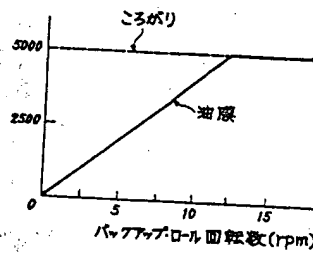
第 5 図



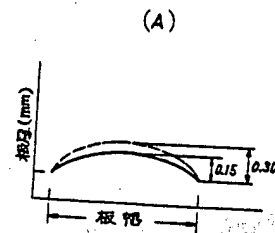
第 6 図



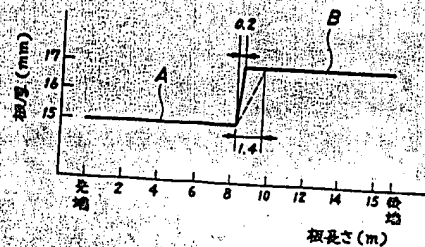
第 7 図



第 9 図



第 8 図



(B)

